

54321 Deren Blue

Work Order ID 53294



Page 1

October 30, 2009 1:16:29 PM

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: PA Date: 09-10-30 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2650	Rev F
-------	-------

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

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Item ID: D206-642-441
Revision ID: F
Item Name: Replacement Skidtube

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Setup Start



Stop



Start Date: 29/10/2009 Start Qty: 1.00
Required Date: 09/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod ☒ M112507/M111999 BE 9-11-3

4-Grind weld flush to cap on top surface only. BE 9-11-3

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

> 9-11-3

9-11-3

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Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
		0.00							
Skidtubes									
Skidtubes	QC5								
	Memo								
	Install D2680-041 Not plate as per Dwg								
130		0.00							
		0.00							
QC									
Quality Control									
	QC10- Inspect visual per QSI004- ground welds								
	Memo								

2/209/11/03

Chemical conversion

QC3

DD

9-11-3

1 11/11/13

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Item ID: D206-642-441
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Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 29/10/2009 Start Qty: 1.00
Required Date: 09/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)
2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)
3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.
4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting
Start Date: ☐ 9/11/09 ☐ Time: ☐ 4:15 ☐
Finish Date: ☐ 9/11/09 ☐ Time: ☐ 9:00AM
A/R ☐ Sikaflex-291 ☐ M11239 ☐
Sikaflex expiry date: ☐ 10/2/09

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ Sorkulay

9/11/3



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Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R ☐ Aluminum Rod ☒ M112507 BE 09/11/04

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

165



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ Seallos

1 H 9/11/05

SC

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Item ID: D206-642-441

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Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

170

0.00



HandFinishing

1 11 9/11/15

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D2650

180

0.00



QC10- Inspect visual per QSI004- ground welds

⇒ 801/1606

QC

Memo

0.00

Quality Control



190

0.00



QC5- Inspect part completeness to step on W/O

⇒ 801/1606

QC

Memo

0.00

Quality Control



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Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

Pressure Wash per QSI005 4.3

0.00



HandFinish

+Touch-up Alodine
Memo

0.00

el 09/10/10

(X1)

6

Hand Finishing

205

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

PRIME GREY 110918
SPRAY PAINT DELFLEET BLUE 110077
CLEAR DELFLEET 113088

m/

09

11

11 (1)

Spray Painting

215

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

85

09

11-12

Quality Control

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Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

0.00



HandFinish

HandFinishing

0.00

Memo

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☒ M 11239

Sikaflex expiry date: ☐ 10/21

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with Sikaflex Clean excess adhesive

A/R ☐ Sikaflex-291 ☒ M 11239

Sikaflex expiry date: ☐ 10/21

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: M 112603

BF 09-11-17 D.

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Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

=> S o s l u l r s



QC

Memo

0.00

Quality Control

(AL) F

250

Packaging

0.00

PPP 53292



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-441

Location: _____

PPP Rev: _____

9/12/08

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/08
MF 09-12-07

Picklist Print

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Page 1

Work Order ID: 53294



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2620RevB		Manufactured	No			110	Each	13.0000	1.0000			
-----------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Skidtube, 206 Skidtube

Handwritten: 9-11-3

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

13

45898

13

D2646RevC		Manufactured	No			120	Each	44.0000	1.0000			
-----------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Aft Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

44

20208

0

43801

1

46327

4

48109

39

D2647RevF		Manufactured	No			140	Each	23.0000	1.0000			
-----------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

23

10773

7

43846

16

Handwritten: 09-11-17

Handwritten: 9-11-3

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Work Order ID: 53294



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2654-7RevE1 		Manufactured	No			160	Each	2.0000	1.0000			
Web												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

52801

352917

2

2

1 09/11/13

CCR264SS3-3 ✓

Purchased

No



Cherry Rivet

170

Each

65.0000

2.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

111548

111827

112314

65

38

1

26

2 09/11/15

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Work Order ID: 53294



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1 ✓		Manufactured	No			170	Each	476.0000	23.0000			



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	83	
51529	83	
Main Warehouse		
ST	393	
36013	5	
47112	382	
48271	6	

D2680-041RevB1 ✓

Manufactured No

170

Each

75.0000

1.0000



Nut Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	75	
33061	10	
44086	65	

23 BE 09/11/04

1 11 9/11/15

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Work Order ID: 53294



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			230	Each	5,073.000	60.0000			



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5073

110511 ✓

5073

AN960C10L ✓ Purchased

No

230

Each

5,735.000

62.0000



Washer

909.11.12

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5735

101291

16

104885

153

105793

236

AN960C10L.

109632 ✓

110985

420

4910

60 BR 09-11-17

PTO

2 BR 09-11-17

W/O: 53294		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.11.12	230	Qty (60) AN960 JD10L REPLACED WITH Qty (60) AN960 C10L M 112612	RR	09-11-12	60	CP 09.11.12 QSI 042	

Part No: D206-642-441 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53294



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD416

Purchased

No

230

Each

4,591.000

1.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4591

108161

519

110523

340

111279

101

111916

482

112314 ✓

3149

16941

0

CR3212-4-03 ✓

Purchased

No

230

Each

292.0000

2.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

292

111359

92

112314

200

1 B209-11-17

2 11/9/11/15

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Work Order ID: 53294



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2651-1RevB

✓

Manufactured

No

230

Each

359.0000

22.0000



Plug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53349

359

43990

81

45490

28

51530

250

D2651-3RevB

✓

Manufactured

No

230

Each

991.0000

22.0000



O-Ring

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

991

43849

3

46114 ✓

988

22 PR 09-11-17.

22 PR 09-11-17.

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Work Order ID: 53294



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3535-15RevB Manufactured No



Wearshoe

230 Each 22.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

17

51671 ✓

17

Main Warehouse

ST

5

30750

4

42233

1

D3535-23RevB Manufactured No



Wearshoe

230 Each 15.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

13

51618 ✓

13

Main Warehouse

ST

2

48156

2

1 09-11-17.

1 09-11-17.

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Work Order ID: 53294



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-37RevB		Manufactured	No			230	Each	18.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	13	
51654 ✓	13	
Main Warehouse		
ST	5	
47374	5	

1 09-11-17

D3536-15RevA

Manufactured No

230

Each

32.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	32	
48159	6	
51600 ✓	26	

1 09-11-17

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Work Order ID: 53294



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-23RevA		Manufactured	No			230	Each	21.0000	1.0000			
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	12	
51609 ✓	12	
Main Warehouse		
ST	9	
30754	1	
47713	8	

1 09-11-17.

D3536-37RevA		Manufactured	No			230	Each	20.0000	1.0000			
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	20	
47375	7	
51641 ✓	13	

1 09-11-17.

Picklist Print

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Work Order ID: 53294



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3537-1RevC		Manufactured	No			230	Each	299.0000	6.0000			
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Wearpad

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	297	
51624	30	
51678 ✓	162	
51679	105	

6 09-11-17.

D3537-3RevC		Manufactured	No			230	Each	60.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Wearpad

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	60	
30758	7	
33881 ✓	17	
35697	36	

1 09-11-17.

October 30, 2009 1:16:33 PM

Shop Packet Print

Page 10

Picklist Print

October 30, 2009 1:16:33 PM

Work Order ID: 53294



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS27039-1-08 Purchased No 230 Each 2,947.000 2.0000



Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2947	
110467 ✓	188	
110552	759	
110835	2000	

2 10/09-11-17.

MS27039-4-06 Purchased No 230 Each 75.0000 1.0000



Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	75	
109061 ✓	75	

1 10/09-11-17.

MS27039C1-08 Purchased No 230 Each 962.0000 60.0000



SCREW

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	962	
19185 ✓	962	

60 10/09-11-17.

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F



NOTES:

MATERIAL: N/A
FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.005 TO 0.010 MAX

IDENTIFICATION: NONE

WEIGHT: N/A

WELD PER DART QSI 004

DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015

) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.

) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

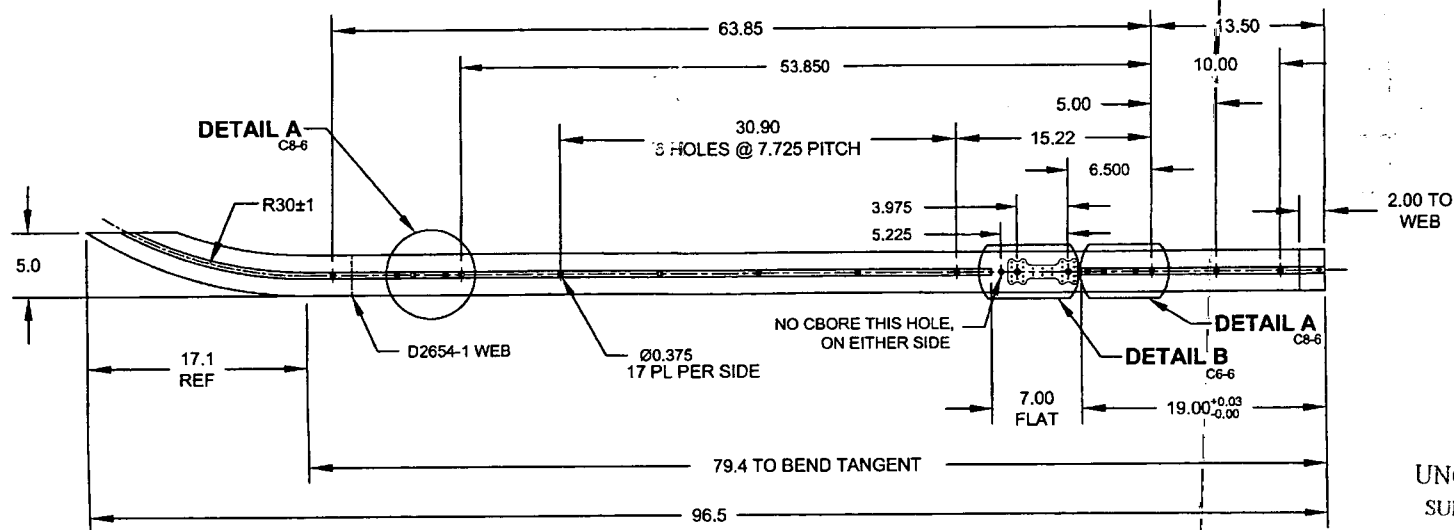
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0910-30

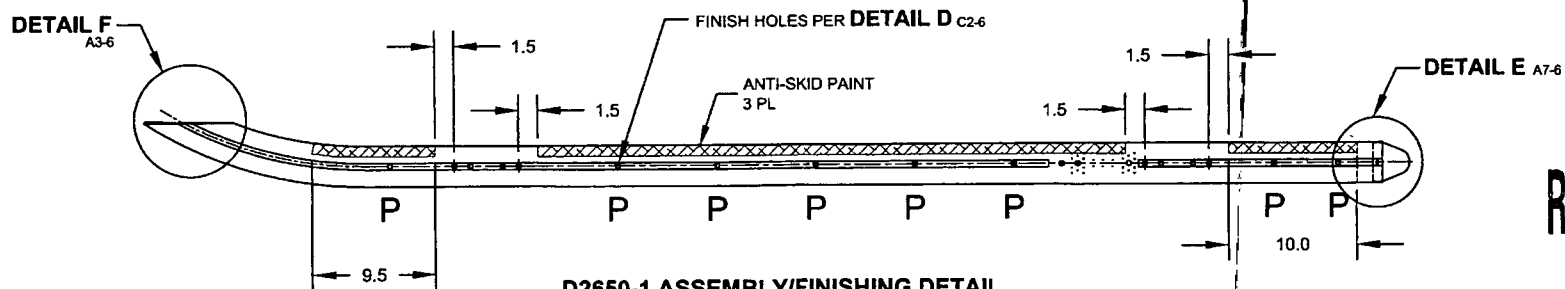
RELEASED
08-08-08

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
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D2650-1 BENDING/DRILLING DETAIL

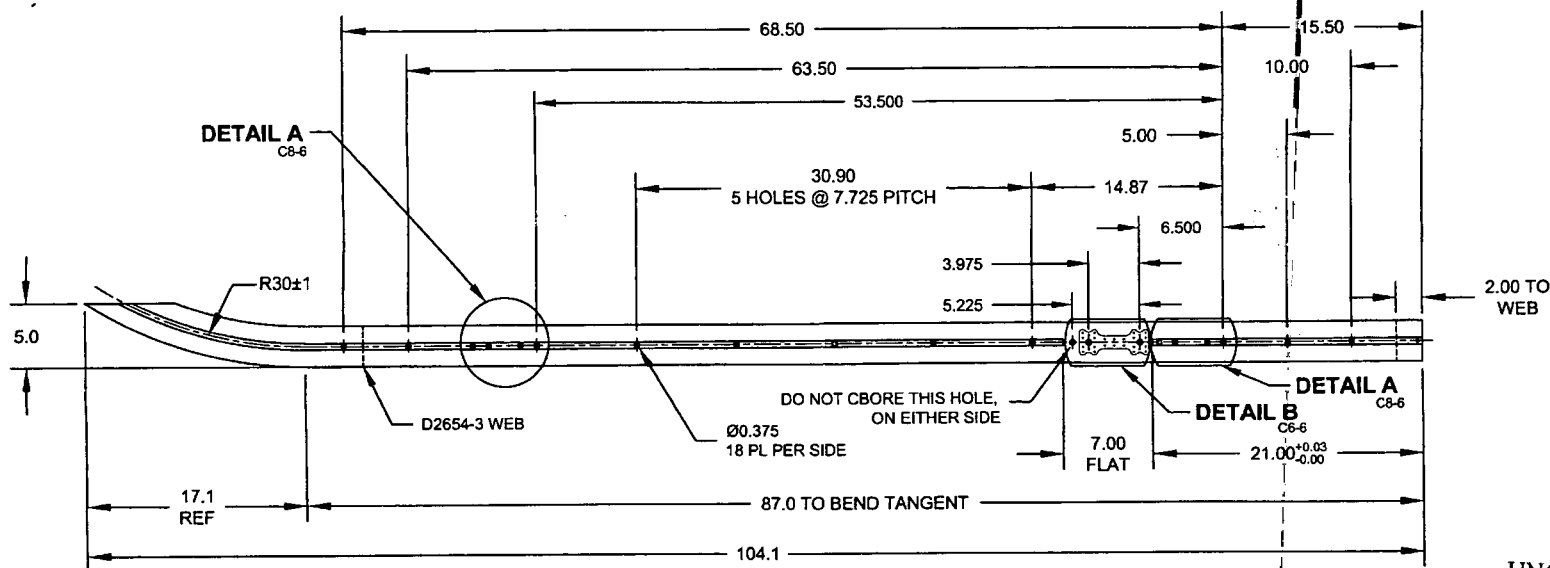
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D2650-1 ASSEMBLY/FINISHING DETAIL

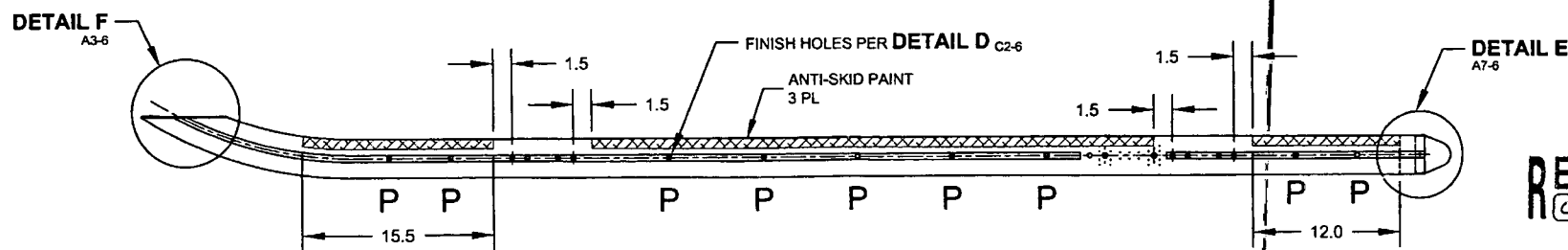
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D2650-3 BENDING/DRILLING DETAIL

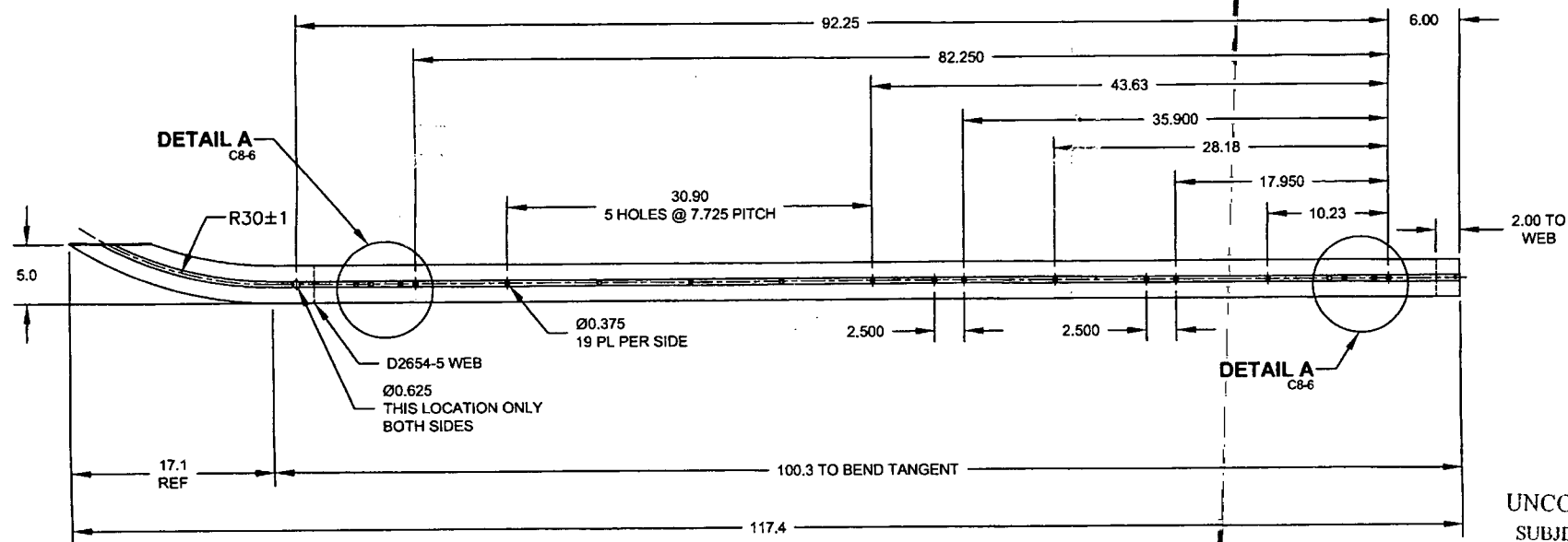
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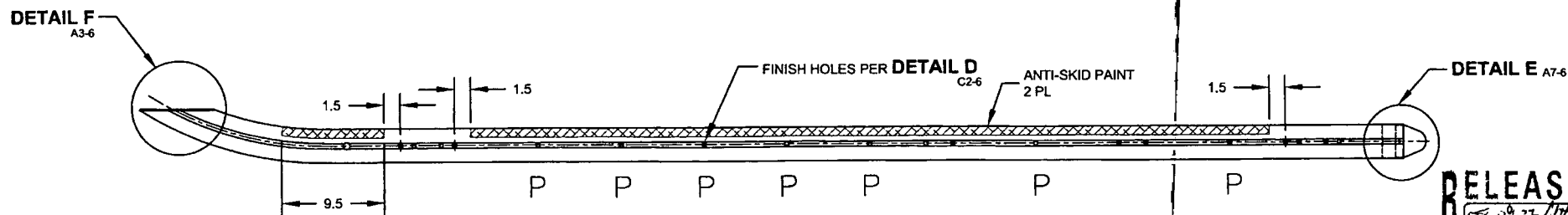
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D2650-5 BENDING/DRILLING DETAIL

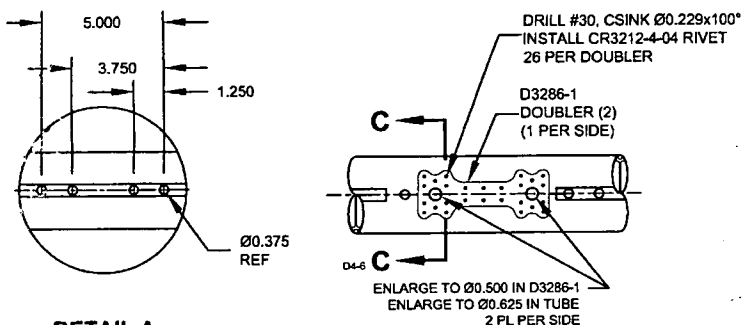
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D2650-5 ASSEMBLY/FINISHING DETAIL

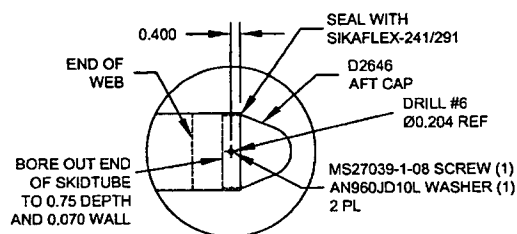
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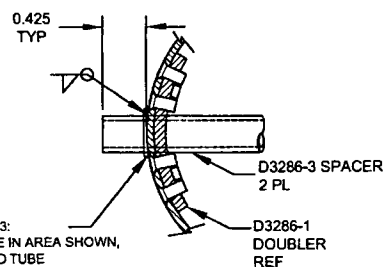
DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

DETAIL B
SCALE 2X
C3-2
C3-3

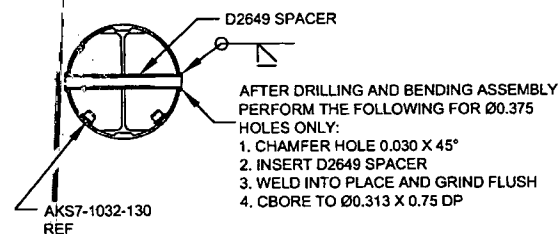


DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5

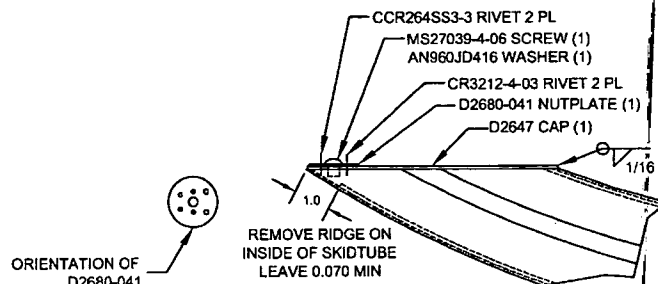
SECTION C-C C7-6
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5






DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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NO. 214

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52855
Part number: D206-H42-251
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Lat Dunt Date of Test Coupon 09.10.29

Welder Barclay Elliott Date of Test Coupon 09.10.29

The above named individual is qualified in accordance with AWS D17.1.2001 to weld